

Date: Wednesday, 21/05/2008 1:04:34 PM
 User: Linda Lacelle

Process Sheet

01C

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: HEADREST ADAPTER	
Job Number	: 05004		Part Number	: D3773041	
Estimate Number	: 13333		Drawing Number	: PROTO	
P.O. Number	:		Project Number	:	
This Issue	: 21/05/2008 S.O. No. :		Drawing Revision	: PROTO 08.05.21	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : R&D LG FAB		Due Date	: 28/05/2008 Qty: 4 Um: Each	
Previous Run	: 39372				
Written By	:				
Checked & Approved By	:				
Comment	: Est Rev:A 08.05.21 new issue DD verified by:ec				

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	Pick Packing Kit	
2.0	D37731	Adapter
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	
	Adapter	
	batch: B39108	
3.0	D37733	Leg
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	
	Leg	
	batch: B38889	
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1	
	1- locate top hole with a 3/16" dowel pin and tack weld D3773-1 adapter to D3773-3 leg as per dwg D3773	
	****take dowel pin out before welding****	
	2- weld as per dwg D3773 QSI004	
	304 S.S. Welding Rod Batch: M107051	

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Drawing Name: HEADREST ADAPTER

Job Number: 05004

Part Number: D3773041

Job Number:

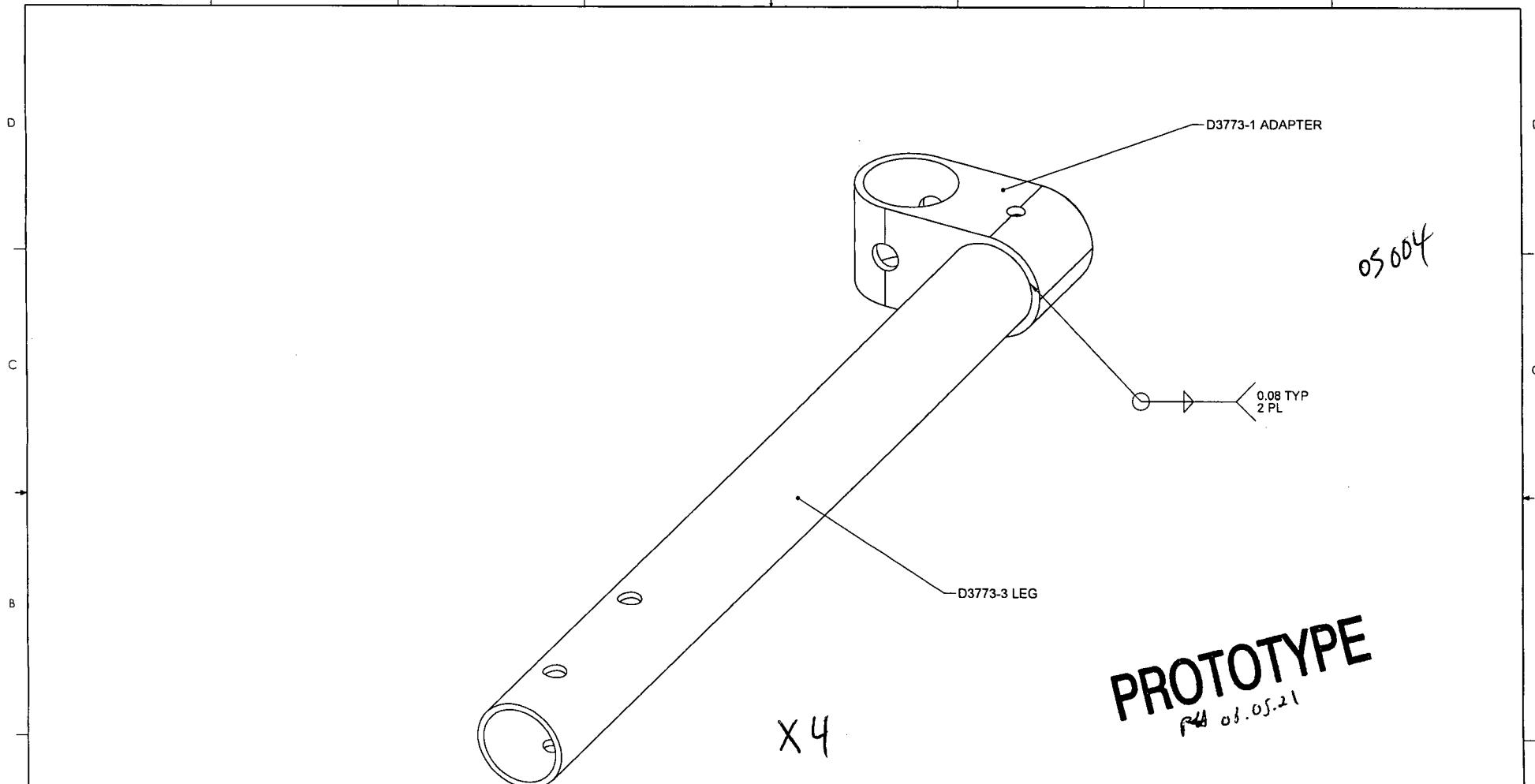


Seq. #:	Machine Or Operation:	Description :
5.0	QC5	INSPECT WORK TO CURRENT STEP
		ENGINEERING APPROVAL
Comment:	INSPECT WORK TO CURRENT STEP	
6.0	QC9	VISUAL WELDING INSPECTION
Comment:	VISUAL WELDING INSPECTION	
7.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment:	PACKAGING RESOURCE #1 Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock Location: _____	
8.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment:	FINAL INSPECTION/W/O RELEASE	

Job Completion



8 7 6 5 4 3 2 1



- NOTES:
- 1) MATERIAL: SEE D3773-1-3
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3773-1, 0.40 lbs
D3773-3, 0.69 lbs
 - 8) WELD: PER DART QSI 004

REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	HS	DRAWING NO.	REV. A	
CHECKED		D3773	SHEET 1 OF 3	
MFG. APPR.		TITLE	SCALE	
APPROVED		HEADREST ADAPTER	NTS	
DE APPR.				
DATE	08.05.05			

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8 7 6 5 4 3 2 1

8

7

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4

3

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1

D

C

B

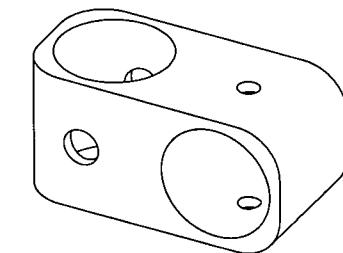
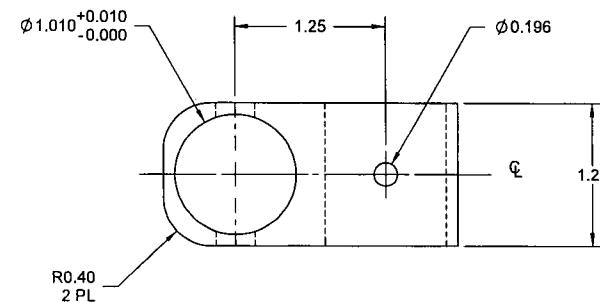
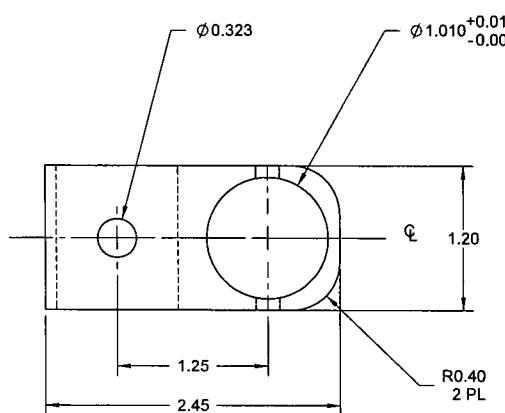
A

D

C

B

A



PROTOTYPE
REV 00.05.21

D3773-1 ADAPTER

NOTES:

- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B1.20X1.20)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3773	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HEADREST ADAPTER	1:1
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